

Work Order ID 79214

January-23-12 3:15:03 PM

slp feb

79214

Page 1

Item ID: D3990-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Guard
 Start Date: 1/23/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 2/03/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|---------------------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3990 | <i>A C per ECN 12.513</i> | | | | | | | | |

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut Blank as per File d3990-1-blank

B12-1-24

(12)

110 0.00
110
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Machine as per Folio FA845
 Folio Rev: *AA*
 Dwg Rev: *C*
 Deburr as per Dwg

? Rev. C

SC

12/10/128

12-01-27

Work Order ID 79214

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79214

Page 2

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|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | | | | | | |
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | | |
| 140 *140* Packaging Packaging | Identify as per dwg & Stock Location: <u>ST206</u> Memo <u>PDA 79287</u> 104 | 0.00 0.00 | | | | | | | |

Handwritten initials

12/6/28

Handwritten signature

12-01-25

Ø 12

Handwritten signature and circled 12

Picklist Print

January-23-12 3:15:02 PM

Page 1

Work Order ID: 79214

Parent Item: D3990-1

Parent Item Name: Cable Guard

Start Date: 1/23/12

Required Date: 2/03/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB1750X1000X 4800 | | Purchased | No | | | 100 | sf | 0.0000 | 1.75 | 18.421053 | | | |
| UHMW 1.75x1.00x48.00 | | | | | | | | | | B 12-1-24 | | | |

MUHMWB10

120035

| | | |
|--------------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 79214 |
| Description: Cable Guard | | Part Number: D3990-1 |
| Inspection Dwg: D3990 | Rev: A | Page 1 of 1 |

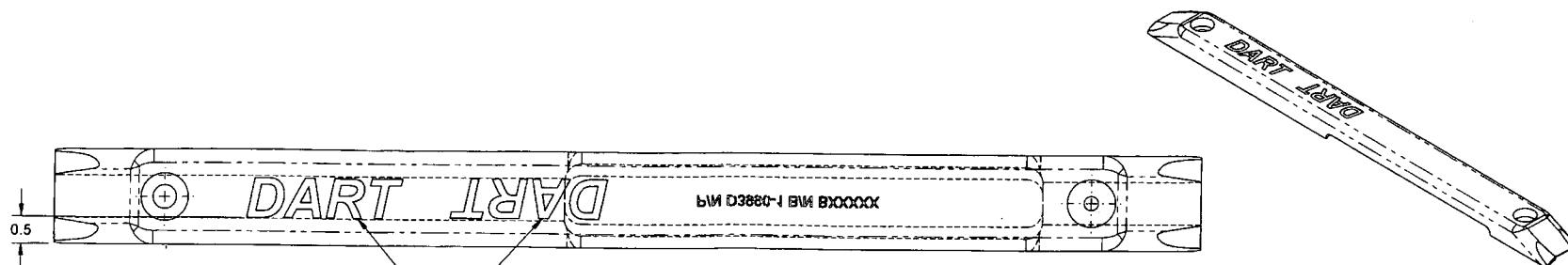
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

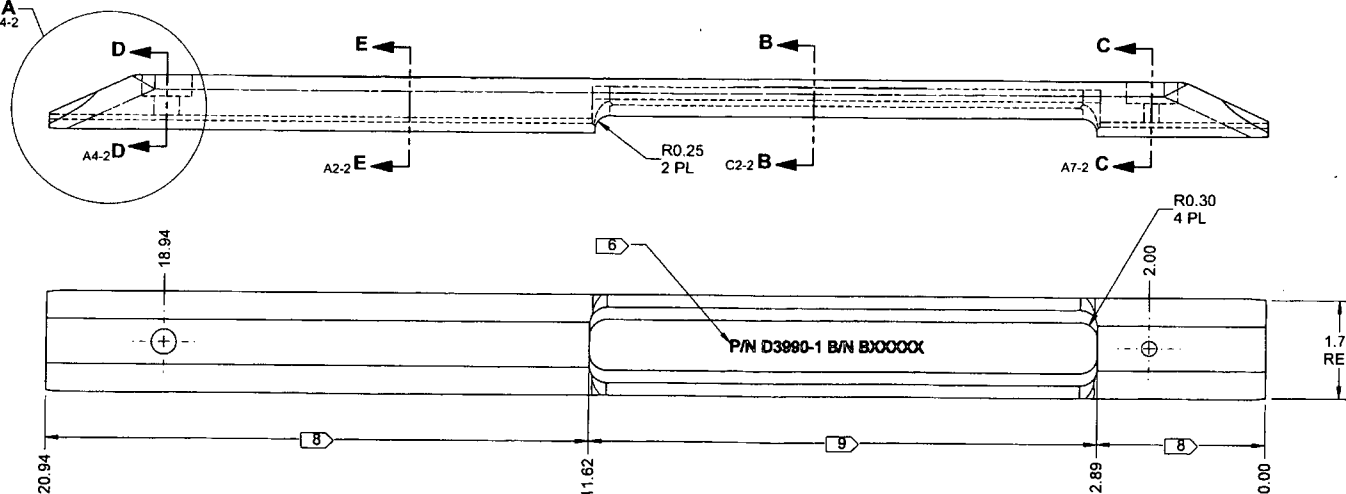
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 20.94 | +/-0.030 | 20.92 | ✓ | | tape | |
| 11.62 | +/-0.030 | 11.62 | ✓ | | tape | |
| 2.89 | +/-0.030 | 2.87 | ✓ | | vern | |
| 1.75 REF | +/-0.030 | 1.748 | ✓ | | " | |
| 2.00 | +/-0.030 | 1.979 | ✓ | | " | |
| 18.94 | +/-0.030 | 18.9375 | ✓ | | tape | |
| 0.5 | +/-0.100 | .5 | ✓ | | rad gauge | |
| 0.65 | +/-0.030 | .65 | ✓ | | vern | |
| 0.88 | +/-0.030 | .884 | ✓ | | " | |
| 1.31 | +/-0.030 | 1.317 | ✓ | | " | |
| 0.14 | +/-0.030 | .156 | ✓ | | micrometer | |
| 0.36 | +/-0.030 | .361 | ✓ | | " | |
| 0.10 | +/-0.030 | .125 | ✓ | | vern | |
| Ø0.875 | +/-0.010 | .873 | ✓ | | vern | |
| 0.37 | +/-0.030 | .371 | ✓ | | " | |
| 0.95 | +/-0.030 | .950 | ✓ | | " | |
| 0.70 | +/-0.030 | .707 | ✓ | | " | |
| 0.78 | +/-0.030 | .800 | ✓ | | " | |
| Ø0.261 | +0.006/-0.001 | .260 | ✓ | | " | |
| Ø0.875 | +/-0.010 | .873 | ✓ | | vern | |
| 0.37 | +/-0.030 | .37 | ✓ | | " | |
| 0.70 | +/-0.010 | .709 | ✓ | | " | |
| 0.95 | +/-0.030 | .953 | ✓ | | " | |
| 0.78 | +/-0.030 | .800 | ✓ | | " | |
| Ø0.438 | +0.006/-0.001 | .438 | ✓ | | " | |
| 1.75 | +/-0.030 | 1.742 | ✓ | | " | |
| 0.70 | +/-0.030 | .707 | ✓ | | " | |
| 0.95 | +/-0.030 | .956 | ✓ | | " | |
| 0.78 | +/-0.030 | .801 | ✓ | | " | |
| R2.0 | +/-0.100 | 2.0 | ✓ | | 4" tubing | |

| | | | |
|---------------------------------|--------------------------------|---------------------|------------------------------|
| Measured by: <i>[Signature]</i> | Audited by: <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: 12-01-27 | Date: 12-01-27 | Date: | N/A |
| Rev | Date | Change | Revised by |
| A | 09.11.11 | New Issue | KJ <i>[Signature]</i> |
| | | | Approved: <i>[Signature]</i> |

8 7 6 5 4 3 2 1



DETAIL A
C4-2



11 D3990-1 CABLE GUARD

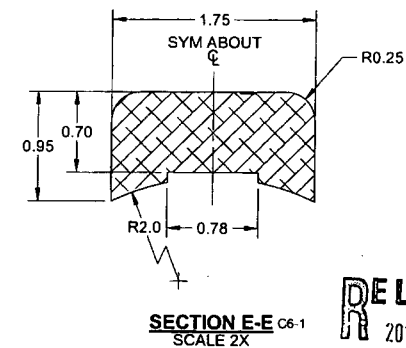
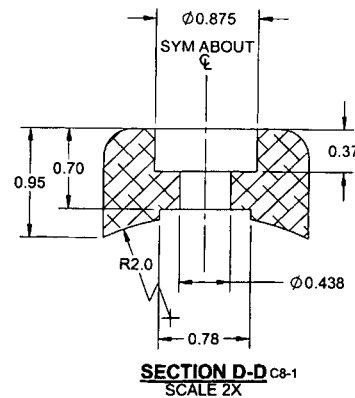
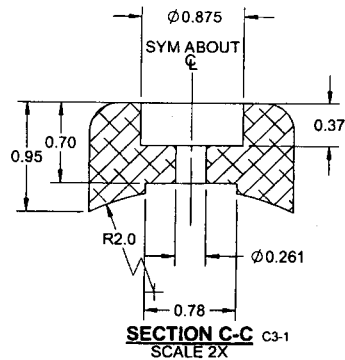
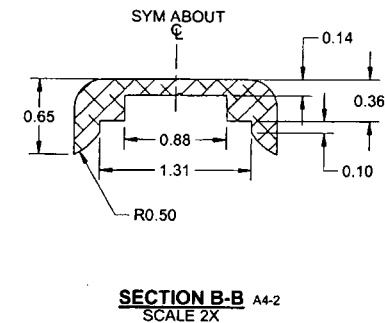
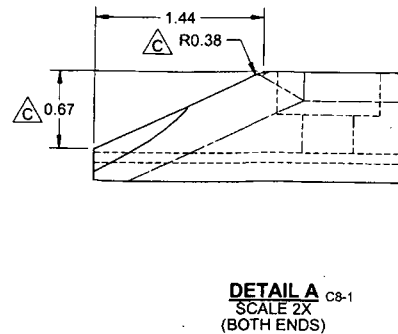
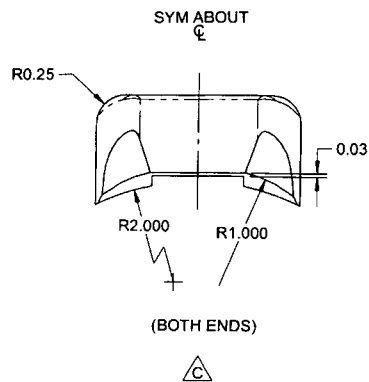
NOTES:

- 1) MATERIAL: MAKE FROM BLACK UHMW
REF DART SPECIFICATION MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3990-1" AND B/N TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25
- 7) WEIGHT: 0.63 lbs
- 8) MACHINE CONSTANT SECTION E-E, EXCEPT FOR DETAIL A
- 9) MACHINE CONSTANT SECTION B-B, EXCEPT FOR TRANSITIONS
- 10) ENGRAVE "DART" LOGO ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25, 2 PL
- 11) BLEND OUT ALL TOOL MARKS AFTER MACHINING

WLB 19214

RELEASE
2012-01-24

| | | | |
|------------|---|--|--------------|
| C | SEE SHT 2 DETAIL A, FILLETS LEADING AND TRAILING EDGE OF PART BLENDED FOR SMOOTH TRANSITION. NOTE 11 ADDED. | AJS | 12.01.23 |
| B | SEE SECTION E-E, ZONE B4-2 0.25 RAD ADDED. | AJS | 11.11.10 |
| A | NEW ISSUE | HS | 09.08.28 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>14</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>14</i> | D3990 | SHEET 1 OF 2 |
| APPROVED | <i>14</i> | TITLE | SCALE |
| DE APPR. | <i>14</i> | CABLE GUARD | NTS |
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R 2012-01-24 D

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| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3990 | SHEET 2 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | CABLE GUARD | NTS |
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